

Work Order ID 163600

Monday, July 03, 2017 11:24:50 AM

163600

Ship JULY 14th

Page 1

Item ID: D3168-042 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Step Assembly, Low Short RH
 Start Date: 7/4/2017 Start Qty: 1.00 *1* Cust Item ID:
 Required Date: 7/7/2017 Req'd Qty: 1.00 *1* Customer:
 Reference:

Approvals: Process Plan: 21 Date: JUL 03 2017 Tooling: Date: Run Start *NR1*
 QC: Date: SPC (Y/N): Date: Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject. Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3168	B								

110 0.00
 110 Large Fab
 Large Fab Memo 0.17
 Large Fab 1-Cut D2622-120C extrusion to 57.090" long as per Dwg D3168
 2-Drill extrusion as per Dwg D3168 using Jig DT8680 for rivets.****(Use only 1st 6holes)****
 3-Deburr

1x 17-07-13

120 0.00
 120 QC6- All purchased or subcontracted products
 QC Memo 0.00
 Quality Control

17-07-14 DAS 9 9-89 PTO

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☒

Work Order: <u>163600</u> Part No. <u>D3168-042</u> NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																																	
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Date :		Step #:		QTY Effective :			MRB (QSI042) Approval DAS 9 9-89																																																																		
Description Work Order Deviation				Disposition				17-02-14 Completed By DFB 17/07/20																																																																	
Permanent change to QCS as per QSI02								Lead hand / Supervisor Approval Verification																																																																	
								QC / QA Coordinator Approval																																																																	
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OTHER :																																																																									

Work Order ID 163600

Monday, July 03, 2017 11:24:50 AM

163600

Page 2

Item ID: D3168-042 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Step Assembly, Low Short RH
Start Date: 7/4/2017 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 7/7/2017 Req'd Qty: 1.00 ***1*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* Large Fab Large Fab	Weld per dwg A/R Aluminum rod Batch: _____ Large Fab Memo 1-Bevel end for welding FWD ONLY 2-Weld Support and end plate, as per QSI 004 & Dwg D3168 A/R Aluminum Rod <u>M136158</u> 3- Grind end plate flush as per dwg	0.00 1.39							x1 2017.07.13 S.L. DAS 24 9-89
140 *140* QC Quality Control	QC9- Inspect visual per QSI004- Fusion Welds Memo	0.00 0.00							0 17.07.14 DAS 9 9-89
150 *150* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.02							0 17.07.14 DAS 9 9-89

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																													
Date :		Step #:		QTY Effective :				MRB (QS1042) Approval																																																									
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval																																																									
Root Cause		FAULT CATEGORY																																																															
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐	Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐	Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐	Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐	Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐	Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐	Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐	Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐	LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐	Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐	Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____			
Misidentified ☐	Past Due ☐																																																																

Monday, July 03, 2017 11:24:50 AM

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(X1) ~~0~~ 20170717
BEB

/ JUL 18 2017

 DAS
 24
 9:59

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition			
TDS 3 1 JUL				Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : ☐					

163600

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N900040100

Setup Start *NS1*

Stop *NS2*

Start Date: 7/4/2017 **Start Qty:** 1.00 ***1***

Cust Item ID:

Required Date: 7/7/2017 Req'd Qty: 1.00 * 1 *

Customer:

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Operation Description

Set Up/ Run Hours

Tool ID	Tool #	Plan Code
---------	--------	-----------

**Accept
Qty**

Reject
QtyReject
Number

**Insp.
Stamp**

180

Weld per dwg A/R Aluminum rod Batch:

0.00

180

Large Fab

0.54

Large Fab

Memo

Rivet Leg Assembly as per Dwg D3168

1-Bevel end for welding

2-Inspect for foreign object as per QSI 024

3-Weld end plate as per QSI 004 & Dwg D3168

A/R Aluminum Rod 137078

4- Grind end plate flush as per dwg

190

QC5- Inspect part completeness to step on W/O	0.00
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190

QC

Memo

0.00

Quality Control

① 17.07.18 PD.

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐		Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐					
		OTHER : ☐							

163600

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N900040100

Setup Start *NS1*

Stop *NS2*

Start Date: 7/4/2017 **Start Qty:** 1.00 ***1***

Cust Item ID:

Required Date: 7/7/2017 **Req'd Qty:** 1.00 *** 1 ***

Customer:

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Set Up/ Run Hours

Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
---------	--------	-----------	------------	------------	---------------	-------------

Touch up alodine

0.00

200

Memo

0.35

HandFinish

Hand Finishing

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00
--	------

0.00

210

Memo

0.49

Powdercoat

Powder Coating

START TIME: 10:45 am
OVEN TEMPERATURE: 320°
FINISH TIME: 11:15 am

Wing Walk as per dwg QSI005 4.4 Batch M1379 0001

2107

220

Memo

0.96

HandFinish

Hand Finishing

DQA: _____ Date: _____



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Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐							
OTHER : ☐									

Work Order ID 163600

Monday, July 03, 2017 11:24:50 AM

163600

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Item ID: D3168-042

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Step Assembly, Low Short RH

Start Date: 7/4/2017 Start Qty: 1.00

1

Cust Item ID:

Required Date: 7/7/2017 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
230	QC3- Inspect Part Finish	0.00							DAS 38 9-88
230									
QC	Memo	0.00							
Quality Control									JUL 20 2017
290	Identify as per dwg & Stock Location: _____	0.00							
290	Packaging								
Packaging	Memo	0.00							
Packaging									
300	QC21- Final Inspection - Work Order Release	0.00							
300									
QC	Memo	0.10							
Quality Control									

DAS
21
9-89

JUL 20 2017

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date : _____		Step #: _____		QTY Effective : _____			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐							
		OTHER : ☐							

Picklist Print

Monday, July 03, 2017 11:24:54 AM

Page 1

Work Order ID: 163600

163600

Parent Item: D3168-042

D3168-042

Parent Item Name: Step Assembly, Low Short RH

Start Date: 7/4/2017

Required Date: 7/7/2017

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP REV:A 16.03.15 NEW ISSUE DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3067-1		Manufactured	No			180	Each	171.0000	1	1			DAS 24 9-89
D3067-1									**			JUL 20 2017	
End Plate													

Location	Loc Qty	Loc Code
WA003	171	
159903	61	
160540	110	

D2622-120C		Manufactured	No			130	Each	51.5000	0.5	0.5			
D2622-120C									**				
Step Extrusion													

Location	Loc Qty	Loc Code
WA003	51.5	
152316	18.5	
157441	33	

D3067-1		Manufactured	No			130	Each	171.0000	1	1			DAS 24 9-89
D3067-1									**			JUL 20 2017	
End Plate													

Location	Loc Qty	Loc Code
WA003	171	
159903	61	
160540	110	

D3077-1		Manufactured	No			180	Each	4.0000	2	2			DAS 24 9-89
D3077-1									**			JUL 20 2017	
Step Leg													

Location	Loc Qty	Loc Code
WA003	4	
151275	4	

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Description Work Order Deviation				Disposition																					
JUL 2 3 2011							Completed By																		
							Lead hand / Supervisor Approval Verification																		
							QC / QA Coordinator Approval																		
Root Cause		FAULT CATEGORY																							
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Picklist Print

Monday, July 03, 2017 11:24:54 AM

Page 2

Work Order ID: 163600

163600

Parent Item: D3168-042

D3168-042

Parent Item Name: Step Assembly, Low Short RH

Start Date: 7/4/2017

Required Date: 7/7/2017

Start Qty: 1.00

Required Qty: 1.00

D3170-1 Manufactured No

180 Each 2.0000 2 2

D3170-1

Spacer

** JUL 20 2017 DAS 24 2 9-89

Location

Loc Qty

Loc Code

WA003

2

120606

2

B163605 → 2

D3219-5 Manufactured No

180 Each 31.0000 2 2

D3219-5

Plate

** JUL 20 2017 DAS 24 2 9-89

Location

Loc Qty

Loc Code

WA003

31

146687

31

x 2 S.L 2017-07-13

MS20600-AD4W4 Purchased No

180 Each 1,769.000 12 12

MS20600-AD4W4

Rivet

** JUL 20 2017 DAS 24 2 9-89

Location

Loc Qty

Loc Code

CCK004

511

M135704

11

M137820

500

ST308

497

M137587

497

WA003

761

M135442

204

M136986

108

M137412

449

12

Monday, July 03, 2017 11:24:54 AM

Shop Packet Print

Page 2

DQA: _____ Date: _____



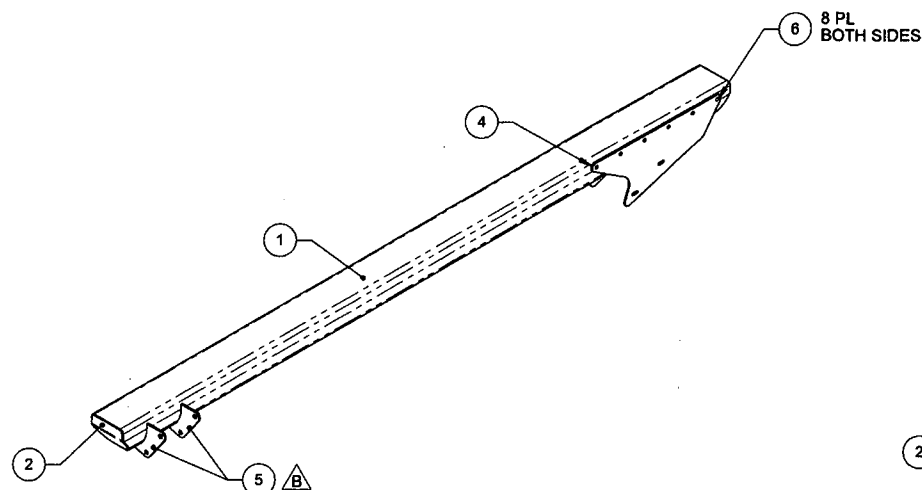
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Work Order update only ☐

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OTHER : _____																																																																				

ITEM	QTY	P/N	DESCRIPTION
	X	D3168-041	STEP ASSEMBLY, LOW SHORT (LH)
1	1	D2622-058	STEP EXTRUSION
2	2	D3067-1	END PLATE
3	2	D3077-1	STEP LEG
4	2	D3170-1	SPACER
5	2	D3219-5	PLATE
6	12	MS20600AD4W4	RIVET, BLIND



D3168-041 STEP ASSEMBLY, LOW SHORT (LH)

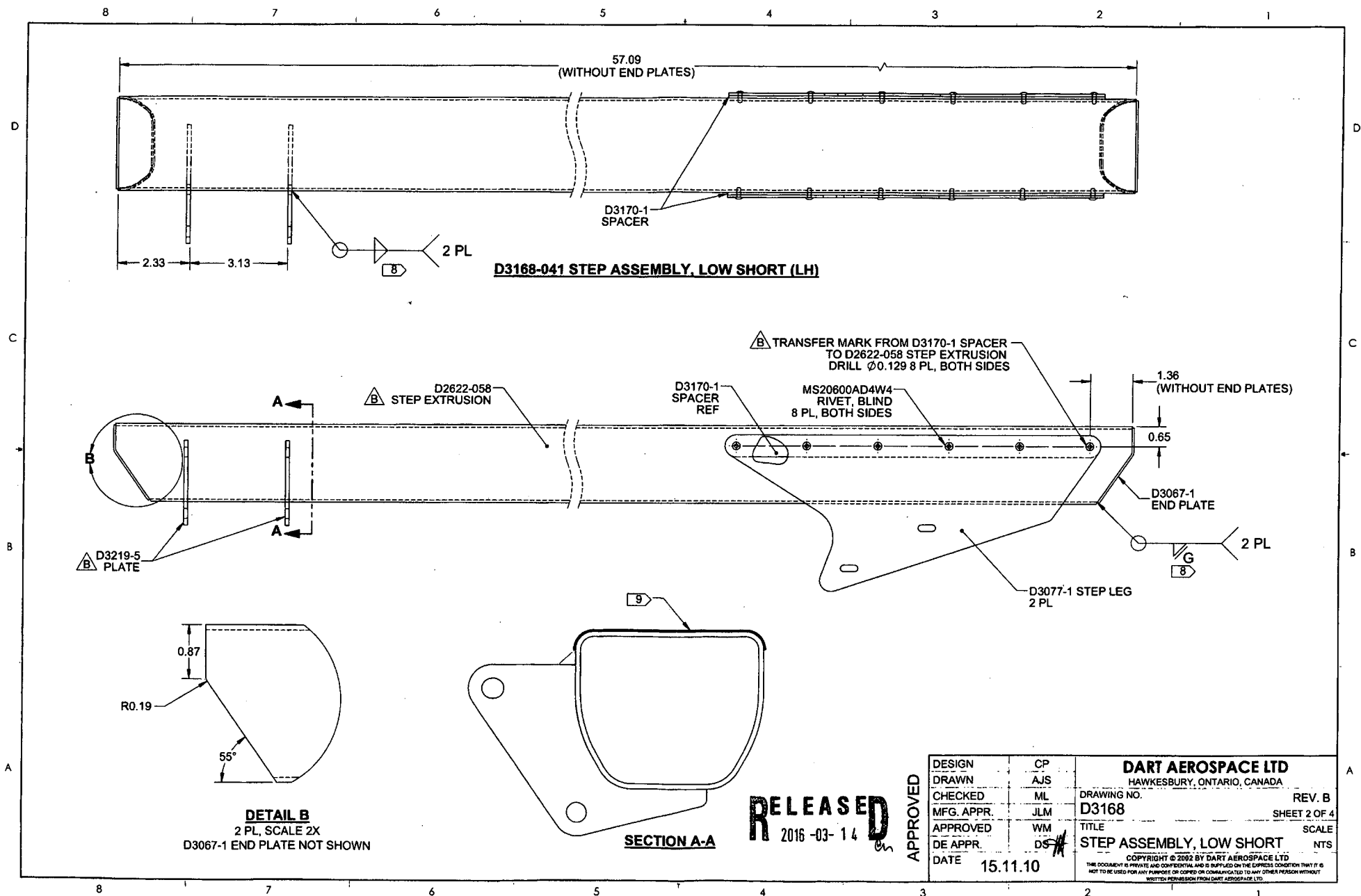
NOTES:

- 1) MATERIAL: NONE
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY PER QSI 044
- 7) WEIGHT: 5.03 lbs
- 8) WELD PER DART QSI 004
- 9) APPLY BLACK ANTI-SKID PAINT ON THE TOP SURFACE TO THE BOTTOM
OF THE TOP RADII AS SHOWN PER DART QSI 005 4.4

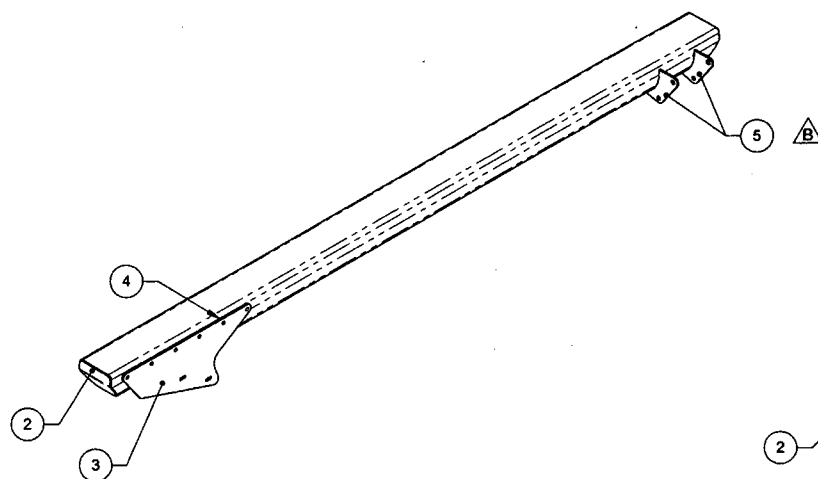
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2016-03-14
EN 86-656

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UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. **163600 MTS**
170703

B	REDRAWN AND REFORMED. ITEM 5 WAS D3168-1 QTY WAS 1. SEE CIR 15-44. PART NUMBER FOR ITEM 1 WAS D2622-60	AJS	15.11.10
A	NEW ISSUE	CP	02.09.11
REV.	DESCRIPTION	BY	DATE
DESIGN	CP	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	ML	DRAWING NO.	REV. B
MFG. APPR.	JLM	D3168	SHEET 1 OF 4
APPROVED	WM	TITLE	SCALE
DE APPR.	DS	STEP ASSEMBLY, LOW SHORT	NTS
DATE	15.11.10	COPYRIGHT © 2002 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



ITEM	QTY -042	P/N	DESCRIPTION
	X	D3168-042	STEP ASSEMBLY, LOW SHORT (RH)
1	1	D2622-058	STEP EXTRUSION
2	2	D3067-1	END PLATE
3	2	D3077-1	STEP LEG
4	2	D3170-1	SPACER
5	2	D3219-5	PLATE
6	12	MS20600AD4W4	RIVET, BLIND



D3168-042 STEP ASSEMBLY, LOW SHORT (RH)

NOTES:

- 1) MATERIAL: NONE
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
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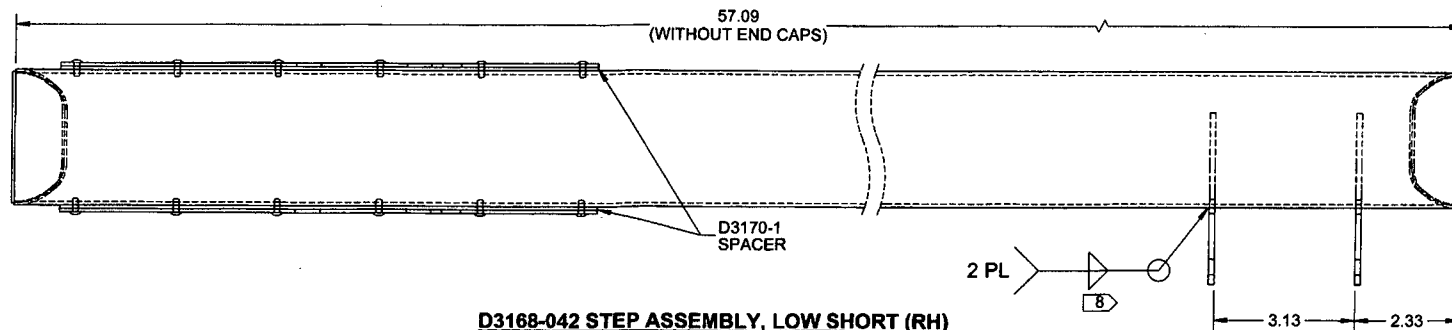
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2016-03-14

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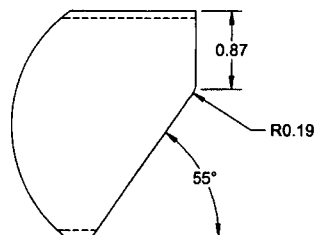
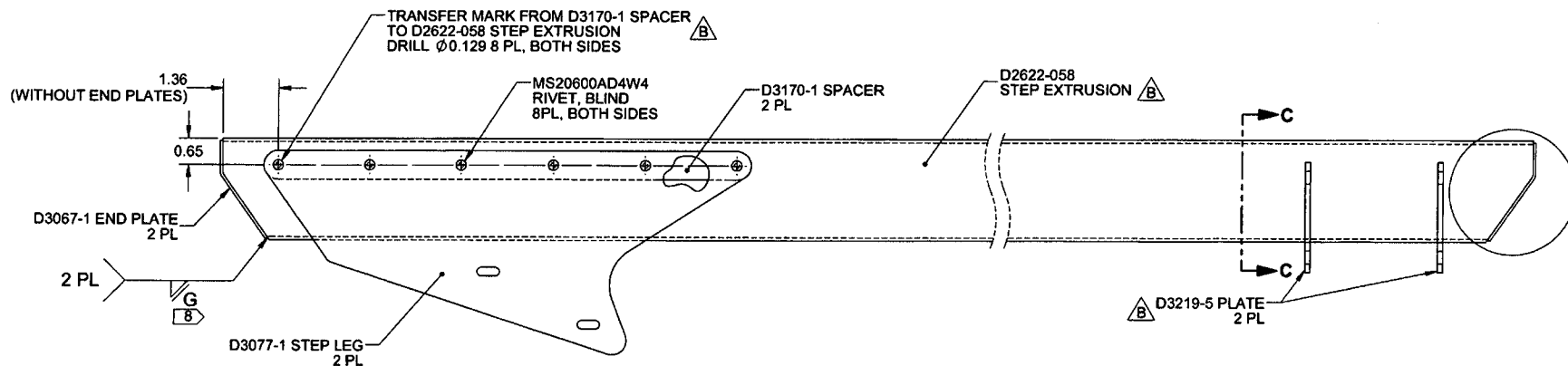
DESIGN	CP
DRAWN	AJS
CHECKED	ML
MFG. APPR.	JLM
APPROVED	WM
DE APPR.	DS
DATE	15.11.10

DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. D3168	REV. B
TITLE STEP ASSEMBLY, LOW SHORT	SHEET 3 OF 4
SCALE NTS	
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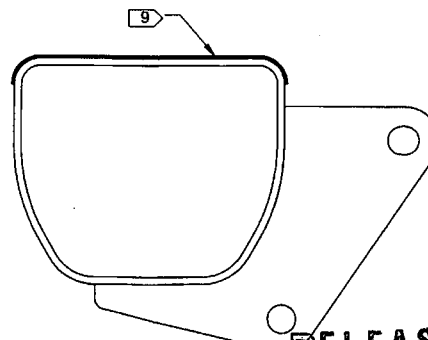
8 7 6 5 4 3 2 1



D3168-042 STEP ASSEMBLY, LOW SHORT (RH)



DETAIL D
2 PL, SCALE 2X
D3067-1 END PLATE NOT SHOWN



SECTION C-C

RELEASE
2016-03-14

DESIGN	CP	DART AEROSPACE LTD
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA
CHECKED	ML	DRAWING NO. D3168
MFG. APPR.	JLM	REV. B
APPROVED	WM	SHEET 4 OF 4
DE APPR.	DSS	SCALE NTS
DATE	15.11.10	TITLE STEP ASSEMBLY, LOW SHORT
COPYRIGHT © 2002 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.		